

Work Order ID 136132

Friday, August 28, 2015 1:52:21 PM

136132

Page 1

Item ID: D2932-1

Accept

N1900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle LH Out, 206

Start Date: 8/28/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 8/28/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: SH / LL Date: 0150831 Tooling: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2932	Rev C								

100

0.01

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.08

HAAS CNC vertical machine #1

Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

12 0 16/03/03

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.01

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

12 0 16/03/03

120

QC1- Inspection performed by CMM

0.00

120

QC

Memo

0.00

Quality Control

12 0 16/03/03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 136132

Friday, August 28, 2015 1:52:21 PM

136132

Page 2

Item ID: D2932-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle LH Out, 206
Start Date: 8/28/2015 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 8/28/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>12</u>	<u>0</u>		DAS 14 9-39 16/03/03
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>12</u>	<u>0</u>		16-3-7/16
150 *150* Powdercoat Powder Coating	White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum <u>m B3962</u> Memo START TIME: <u>3:00</u> FINISH TIME: <u>2:50</u> OVEN TEMPERATURE: <u>2:50</u>	0.00 0.00				<u>12</u>	<u>0</u>	<u>16-03-7</u>	23 34 0-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Picklist Print

Friday, August 28, 2015 1:52:25 PM

Page 1
1

Work Order ID: 136132

136132

Parent Item: D2932-1

D2932-1

Parent Item Name: Saddle LH Out, 206

Start Date: 8/28/2015

Required Date: 8/28/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B00.06.26New DWG rev, (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	25.0000	1	6			
D6101-003									**				
Saddle Billet, 7075													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT045	25	
132646	1	
134038	24	

M135957

12

Handwritten signature and date 10/02/29

DQA: _____ Date: _____

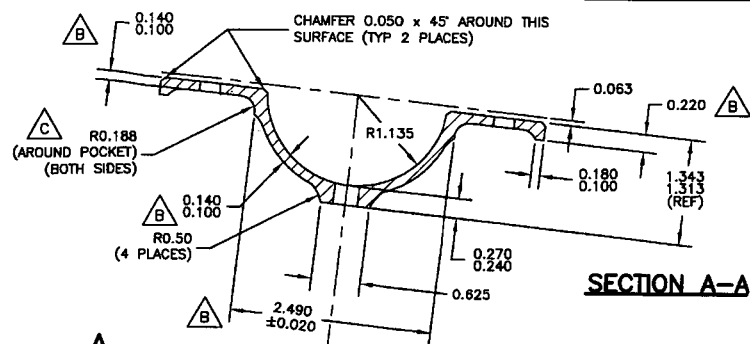


WORK ORDER NON-CONFORMANCE / UPDATE

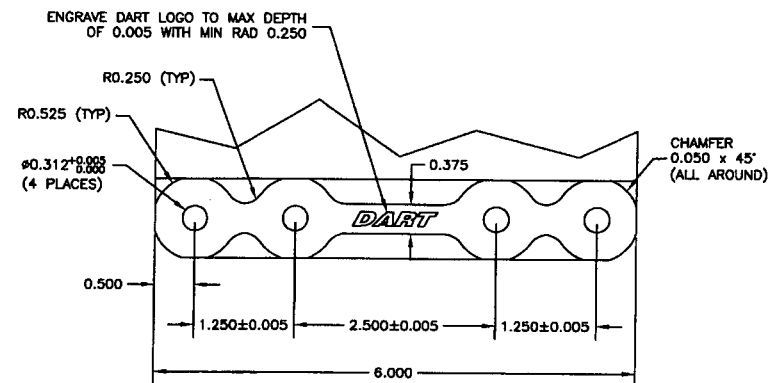
QA Closed: _____ Date: _____

Work Order update only ☐

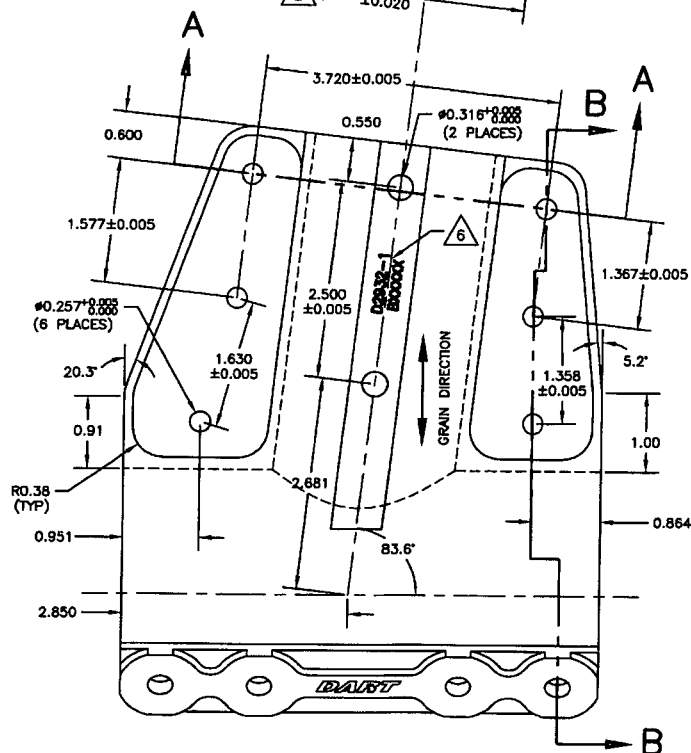
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



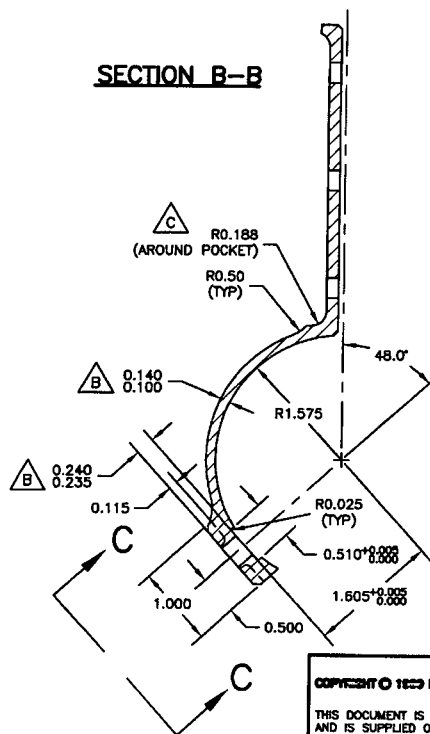
SECTION A-A



VIEW C-C



SECTION B-B



D2932-1 LH SADDLE (SHOWN)

D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

20150831 SH 136132

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC. BOLLEVILLE, WA
CHECKED	PH	DRAWING NO. D2932
DATE	06.11.09	TITLE SADDLE OUTSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

COPYRIGHT © 1993 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

RELEASED

07-02-12

DART AEROSPACE LTD		Work Order: 136132
Description: 206 Saddle, Outboard, Left side		Part Number: D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.128	0.127	0.127	0.127		
B	0.100	0.140		0.128	0.127	0.127	0.126		
C	0.100	0.140		0.119	0.118	0.120	0.120		
D	0.210	0.230		0.218	0.224	0.225	0.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.313	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.239		
N	0.100	0.140		0.122	0.122	0.124	0.123		
O	0.540	0.560		0.548	0.548	0.548	0.548		
P	0.490	0.510		0.500	0.499	0.499	0.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		0.249	0.249	0.251	0.251		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.316	0.316	0.316	0.316		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585		1.5745	1.575	1.575	1.575		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				✓	✓	✓	✓		

Measured by:	<i>[Signature]</i>
Date:	16/03/02

Audited by:	DAS
Date:	14 9-30 16/03/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 136132
Description: 206 Saddle, Outboard, Left side	Part Number: D2932-1
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				Ø 5	Ø 6	Ø 7	Ø 8		
A	0.100	0.140		0.128	0.128	0.126	0.127		
B	0.100	0.140		0.128	0.128	0.127	0.117		
C	0.100	0.140		0.117	0.117	0.119	0.118		
D	0.210	0.230		0.224	0.223	0.223	0.223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.239	0.239	0.239		
N	0.100	0.140		0.125	0.124	0.123	0.123		
O	0.540	0.560		0.547	0.548	0.548	0.548		
P	0.490	0.510		0.500	0.500	0.500	0.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		0.250	0.251	0.251	0.251		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.317	0.317	0.317	0.317		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585		1.576	1.576	1.576	1.576		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				✓	✓	✓	✓		

Measured by: <i>[Signature]</i>	DAS
Date: 16/03/02	Audited by: 14
	Date: 9-09 16/03/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 136132
Description: 206 Saddle, Outboard, Left side	Part Number: D2932-1
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	10	11	12	By	Date
A	0.100	0.140		0.126	0.127	0.126	0.126		
B	0.100	0.140		0.127	0.127	0.126	0.126		
C	0.100	0.140		0.120	0.120	0.120	0.120		
D	0.210	0.230		0.225	0.225	0.224	0.223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.121	0.122	0.122	0.122		
O	0.540	0.560		0.548	0.548	0.548	0.548		
P	0.490	0.510		0.500	0.500	0.500	0.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		0.252	0.252	0.251	0.251		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.365	1.365	1.365	1.365		
W	0.316	0.321		0.317	0.317	0.317	0.317		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585		1.578	1.578	1.578	1.578		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				✓	✓	✓	✓		

Measured by:	<i>[Signature]</i>
Date:	16/03/03

Audited by:	DAS
Date:	16/03/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>



Part Number: D2932-1	Rev: C	- Page 1 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2932	Work Order: 136132

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	No. Piece_5 Actual
1	0.120	+0.010/-0.010	0.123	0.124	0.125	0.124	0.125
D2	0.050	+0.010/-0.010	0.050	0.050	0.050	0.050	0.050
3	0.063	+0.010/-0.010	0.059	0.059	0.057	0.058	0.058
4	0.220	+0.010/-0.010	0.221	0.227	0.228	0.227	0.227
5	1.328	+0.015/-0.015	1.323	1.329	1.330	1.330	1.330
D6	0.140	+0.040/-0.040	0.140	0.140	0.140	0.140	0.140
D7	0.120	+0.020/-0.020	0.125	0.126	0.125	0.125	0.123
D8	0.255	+0.015/-0.015	0.247	0.250	0.254	0.253	0.251
D9	0.625	+0.010/-0.010	0.635	0.635	0.635	0.635	0.635
D10	2.490	+0.200/-0.200	2.490	2.490	2.490	2.490	2.490
D11	0.120	+0.200/-0.200	0.123	0.126	0.123	0.123	0.123
D12	0.188	+0.010/-0.010	0.188	0.188	0.188	0.188	0.188
13	0.312	+0.005/0.000	0.313	0.313	0.313	0.313	0.312
14	0.500	+0.010/-0.010	0.502	0.499	0.500	0.501	0.500
15	1.250	+0.005/-0.005	1.249	1.249	1.249	1.250	1.249
16	2.500	+0.005/-0.005	2.499	2.500	2.500	2.500	2.500
17	1.250	+0.005/-0.005	1.250	1.250	1.249	1.250	1.250
18	6.000	+0.010/-0.010	6.000	6.000	6.000	6.000	6.000
D19	0.050	+0.010/-0.010	0.040	0.050	0.040	0.040	0.040
20	0.063	+0.010/-0.010	0.073	0.069	0.064	0.066	0.067
Ang21	48.000	+0.500/-0.500	47.890	47.880	47.906	47.919	47.895
D22	0.510	+0.005/0.000	0.512	0.513	0.512	0.512	0.512
23	1.605	+0.005/0.000	1.608	1.609	1.608	1.608	1.607
24	0.500	+0.010/-0.010	0.505	0.508	0.508	0.508	0.506
D25	1.000	+0.010/-0.010	1.008	1.010	1.010	1.010	1.010
26	0.115	+0.010/-0.010	0.115	0.116	0.115	0.116	0.116
D27	0.235	+0.005/0.000	0.239	0.239	0.238	0.238	0.238
D28	0.120	+0.020/-0.020	0.118	0.115	0.116	0.116	0.116
29	1.575	+0.010/-0.010	1.574	1.575	1.573	1.574	1.574
30	3.720	+0.005/-0.005	3.719	3.718	3.719	3.719	3.718
31	0.550	+0.010/-0.010	0.549	0.550	0.549	0.549	0.549
32	0.316	+0.005/0.000	0.316	0.316	0.316	0.316	0.316

Measured by:
Mathieu Lamarche

Date:
2016-3-3

Audited by:

Date:



Part Number: D2932-1	Rev: C	- Page 2 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2932	Work Order: 136132

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	No. Piece_5 Actual
33	1.367	+0.005/-0.005	1.367	1.367	1.368	1.368	1.367
34	5.200	+0.500/-0.500	5.198	5.210	5.226	5.206	5.197
35	1.358	+0.005/-0.005	1.359	1.359	1.359	1.358	1.359
36	0.864	+0.010/-0.010	0.864	0.864	0.863	0.862	0.863
37	83.600	+0.500/-0.500	83.559	83.559	83.564	83.558	83.556
38	2.681	+0.010/-0.010	2.683	2.682	2.682	2.682	2.682
39	2.850	+0.010/-0.010	2.850	2.850	2.850	2.850	2.850
40	0.951	+0.010/-0.010	0.951	0.953	0.952	0.953	0.952
41	20.300	+0.500/-0.500	20.254	20.254	20.253	20.243	20.242
42	1.630	+0.005/-0.005	1.630	1.630	1.630	1.630	1.630
43	0.257	+0.005/0.000	0.258	0.258	0.257	0.258	0.258
44	1.577	+0.005/-0.005	1.578	1.578	1.578	1.578	1.577
45	0.600	+0.010/-0.010	0.597	0.598	0.597	0.596	0.597
46	2.500	+0.005/-0.005	2.499	2.500	2.500	2.500	2.500
47	1.135	+0.010/-0.010	1.133	1.133	1.133	1.133	1.133

Measured by:
Mathieu Lamarche

Date:
2016-3-3

Audited by:

Date:



Part Number: D2932-1	Rev: C	- Page 1 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2932	Work Order: 136132

Item Ref.	Nominal	Tolerance	No. Piece_6 Actual	No. Piece_7 Actual	No. Piece_8 Actual	No. Piece_9 Actual	No. Piece_10 Actual
1	0.120	+0.010/-0.010	0.124	0.124	0.124	0.124	0.124
D2	0.050	+0.010/-0.010	0.050	0.040	0.050	0.050	0.050
3	0.063	+0.010/-0.010	0.059	0.058	0.058	0.059	0.058
4	0.220	+0.010/-0.010	0.227	0.227	0.227	0.227	0.226
5	1.328	+0.015/-0.015	1.329	1.329	1.329	1.329	1.329
D6	0.140	+0.040/-0.040	0.140	0.140	0.140	0.140	0.140
D7	0.120	+0.020/-0.020	0.125	0.123	0.124	0.125	0.124
D8	0.255	+0.015/-0.015	0.255	0.253	0.252	0.253	0.251
D9	0.625	+0.010/-0.010	0.635	0.635	0.635	0.635	0.635
D10	2.490	+0.200/-0.200	2.490	2.490	2.490	2.490	2.490
D11	0.120	+0.200/-0.200	0.123	0.124	0.123	0.124	0.126
D12	0.188	+0.010/-0.010	0.188	0.188	0.188	0.188	0.188
13	0.312	+0.005/0.000	0.312	0.313	0.313	0.313	0.313
14	0.500	+0.010/-0.010	0.500	0.499	0.501	0.500	0.500
15	1.250	+0.005/-0.005	1.250	1.250	1.249	1.249	1.249
16	2.500	+0.005/-0.005	2.500	2.500	2.499	2.500	2.500
17	1.250	+0.005/-0.005	1.250	1.249	1.250	1.250	1.250
18	6.000	+0.010/-0.010	6.000	6.001	6.000	6.000	6.000
D19	0.050	+0.010/-0.010	0.040	0.040	0.040	0.040	0.040
20	0.063	+0.010/-0.010	0.064	0.073	0.065	0.066	0.064
Ang21	48.000	+0.500/-0.500	47.880	47.866	47.875	47.875	47.868
D22	0.510	+0.005/0.000	0.512	0.513	0.512	0.512	0.513
23	1.605	+0.005/0.000	1.608	1.607	1.607	1.607	1.608
24	0.500	+0.010/-0.010	0.508	0.509	0.507	0.508	0.508
D25	1.000	+0.010/-0.010	1.010	1.010	1.010	1.010	1.010
26	0.115	+0.010/-0.010	0.116	0.116	0.116	0.116	0.117
D27	0.235	+0.005/0.000	0.238	0.238	0.238	0.238	0.238
D28	0.120	+0.020/-0.020	0.115	0.116	0.115	0.114	0.114
29	1.575	+0.010/-0.010	1.574	1.574	1.573	1.574	1.574
30	3.720	+0.005/-0.005	3.719	3.718	3.719	3.719	3.719
31	0.550	+0.010/-0.010	0.549	0.549	0.550	0.549	0.549
32	0.316	+0.005/0.000	0.316	0.316	0.316	0.316	0.316

Measured by:
Mathieu Lamarche

Date:
2016-3-3

Audited by:

Date:



Part Number: D2932-1	Rev: C	- Page 2 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2932	Work Order: 136132

Item Ref.	Nominal	Tolerance	No. Piece_6 Actual	No. Piece_7 Actual	No. Piece_8 Actual	No. Piece_9 Actual	No. Piece_10 Actual
33	1.367	+0.005/-0.005	1.368	1.368	1.367	1.367	1.368
34	5.200	+0.500/-0.500	5.203	5.201	5.208	5.199	5.204
35	1.358	+0.005/-0.005	1.358	1.358	1.358	1.359	1.358
36	0.864	+0.010/-0.010	0.864	0.864	0.863	0.864	0.864
37	83.600	+0.500/-0.500	83.561	83.556	83.563	83.564	83.561
38	2.681	+0.010/-0.010	2.682	2.682	2.681	2.681	2.681
39	2.850	+0.010/-0.010	2.850	2.850	2.850	2.850	2.851
40	0.951	+0.010/-0.010	0.952	0.951	0.953	0.951	0.952
41	20.300	+0.500/-0.500	20.239	20.228	20.249	20.231	20.234
42	1.630	+0.005/-0.005	1.630	1.628	1.630	1.630	1.630
43	0.257	+0.005/0.000	0.258	0.257	0.257	0.258	0.258
44	1.577	+0.005/-0.005	1.577	1.578	1.577	1.577	1.577
45	0.600	+0.010/-0.010	0.597	0.598	0.598	0.597	0.597
46	2.500	+0.005/-0.005	2.500	2.500	2.500	2.500	2.500
47	1.135	+0.010/-0.010	1.134	1.133	1.133	1.134	1.133

Measured by:
Mathieu Lamarche

Date:
2016-3-3

Audited by:

Date:



Part Number: D2932-1	Rev: C	- Page 1 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2932	Work Order: 136132

Item Ref.	Nominal	Tolerance	No. Piece_11 Actual	No. Piece_12 Actual			
1	0.120	+0.010/-0.010	0.124	0.124			
D2	0.050	+0.010/-0.010	0.050	0.050			
3	0.063	+0.010/-0.010	0.059	0.058			
4	0.220	+0.010/-0.010	0.226	0.227			
5	1.328	+0.015/-0.015	1.329	1.329			
D6	0.140	+0.040/-0.040	0.140	0.140			
D7	0.120	+0.020/-0.020	0.124	0.124			
D8	0.255	+0.015/-0.015	0.251	0.251			
D9	0.625	+0.010/-0.010	0.635	0.635			
D10	2.490	+0.200/-0.200	2.490	2.490			
D11	0.120	+0.200/-0.200	0.125	0.124			
D12	0.188	+0.010/-0.010	0.188	0.188			
13	0.312	+0.005/0.000	0.313	0.313			
14	0.500	+0.010/-0.010	0.500	0.500			
15	1.250	+0.005/-0.005	1.249	1.250			
16	2.500	+0.005/-0.005	2.500	2.500			
17	1.250	+0.005/-0.005	1.250	1.250			
18	6.000	+0.010/-0.010	6.001	6.000			
D19	0.050	+0.010/-0.010	0.040	0.040			
20	0.063	+0.010/-0.010	0.072	0.071			
Ang21	48.000	+0.500/-0.500	47.879	47.874			
D22	0.510	+0.005/0.000	0.513	0.513			
23	1.605	+0.005/0.000	1.608	1.607			
24	0.500	+0.010/-0.010	0.508	0.509			
D25	1.000	+0.010/-0.010	1.010	1.010			
26	0.115	+0.010/-0.010	0.116	0.117			
D27	0.235	+0.005/0.000	0.238	0.238			
D28	0.120	+0.020/-0.020	0.116	0.115			
29	1.575	+0.010/-0.010	1.574	1.573			
30	3.720	+0.005/-0.005	3.720	3.718			
31	0.550	+0.010/-0.010	0.550	0.549			

Measured by:
Mathieu Lamarche

Date:
2016-3-3

Audited by:

Date:



Part Number: D2932-1	Rev: C	- Page 2 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2932	Work Order: 136132

Item Ref.	Nominal	Tolerance	No. Piece_11 Actual	No. Piece_12 Actual			
32	0.316	+0.005/0.000	0.316	0.315			
33	1.367	+0.005/-0.005	1.367	1.369			
34	5.200	+0.500/-0.500	5.204	5.203			
35	1.358	+0.005/-0.005	1.359	1.358			
36	0.864	+0.010/-0.010	0.864	0.863			
37	83.600	+0.500/-0.500	83.556	83.555			
38	2.681	+0.010/-0.010	2.682	2.682			
39	2.850	+0.010/-0.010	2.851	2.850			
40	0.951	+0.010/-0.010	0.952	0.952			
41	20.300	+0.500/-0.500	20.234	20.252			
42	1.630	+0.005/-0.005	1.629	1.631			
43	0.257	+0.005/0.000	0.258	0.257			
44	1.577	+0.005/-0.005	1.577	1.577			
45	0.600	+0.010/-0.010	0.598	0.598			
46	2.500	+0.005/-0.005	2.499	2.500			
47	1.135	+0.010/-0.010	1.133	1.133			

Measured by:
Mathieu Lamarche

Date:
2016-3-3

Audited by:

Date: